

# Work Order ID 79329

Wednesday, January 25, 2012 12:49:13 PM

**\*79329\***

Feb 3 Page 1

Item ID: D206-642-611

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Float Skidtube LH

Start Date: 1/24/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 1/31/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference: REWORK

<b>DART</b>		TEL: 1-613-632-3336 FAX: 1-613-632-4443	
TRANSPORT CANADA APPROVAL #09-89			
P/N	D206-642-611	CHG	CHG003
DESC	Float Skidtube LH	STC	SH98-4
LOT	B36176	STC	SA00475SE
WICIDFL	Bell 206A/B	STC	
US PATENT # 5,735,164 CANADA FOREIGN PATENTS PENDING		MADE IN CANADA	

Approvals: Process Plan: *MF*

Date: *12-01-25* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN D206-642	0

150

**\*150\***

HandFinish

Hand Finishing

Memo

PULL FROM STOCK D206-642-611 *B36176*

REMOVE CAP AND WASH LPS3 ENTIRELY OUT OF TUBE PER ECN 09-616

*CHG003*

0.00

0.00

*m/ 12 01 30 ①*  
*Hand Finish 12-1-31*

160

**\*160\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O 0.00

Memo

0.00

*QC 12 01 31 ①*

**B79329 D206-642-611**

# Work Order ID 79329

**\*79329\***

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Wednesday, January 25, 2012 12:49:13 PM

Item ID: D206-642-611

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Float Skidtube LH

Start Date: 1/24/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 1/31/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference: REWORK

Approvals: Process Plan: Date: Tooling: Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170

0.00

**\*170\***

HandFXtube

Memo

0.00

Hand Finishing Crosstubes

4-RE-ASSEMBLE! D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive.  
A/RSikaflex-291 119508  
Sikaflex expire date: 12/08

At 12 - 1 - 31

180

QC5- Inspect part completeness to step on W/O 0.00

**\*180\***

QC

Memo

0.00

Quality Control

12 - 01 - 31

190

Pick Kit 0.00

**\*190\***

Packaging

Memo

0.00

Packaging

REMOVE D3672-5 X 16  
AND REPLACE WITH D3672-7 X 16  
PER DSI 9467 (ECN 09-616)

12/21

# Work Order ID 79329

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Wednesday, January 25, 2012 12:49:13 PM

Item ID: D206-642-611

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Float Skidtube LH

Start Date: 1/24/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 1/31/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference: REWORK

Run Start

**\*NR1\***

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

**\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

200

QC4- 100% Inspect kits for completeness

0.00

**\*200\***

QC

Memo

0.00

Quality Control

210

Identify as per dwg & Stock Location:

0.00

**\*210\***

Packaging

Memo

0.00

Packaging

ID AND STOCK UNDER NEW BATCH NUMBER AND NEW CHANGE NUMBER

ADD NEW PAPERWORK

CHG 004

220

QC21- Final Inspection - Work Order Release

0.00

**\*220\***

QC

Memo

0.00

Quality Control

SP 202-01

M.C.J 12/02/01

MF 12-02-01

# Picklist Print

Wednesday, January 25, 2012 12:49:13 P

Page 1  
T

Work Order ID: 79329

Parent Item: D206-642-611

Parent Item Name: Float Skidtube LH

Start Date: 1/24/2012

Required Date: 1/31/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B05.10.27Revised pick listKJ/EC  
IPP Rev:C 07-12-05 ECN 1080p Rev:L DD verified by:ec  
IPP Rev:D 09-01-06 update part list DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3672-5 Phenolic Washer		Manufactured	No				Each	1,864.0000		-16			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST060		1864							
				35521		1075							
				44679		220							
				50354		569							
D3672-7 Phenolic Washer		Manufactured	No				Each	1,068.0000					
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST060		1068							
				73488		68							
				76279		1000							

Qty -041	Part Number	Description
X	D3288-041	SKIDTUBE ASSEMBLY
1	D2600-1-240	EXTRUSION
1	D2646	AFT CAP
1	D2647	CAP
9	D2649	CROSS BOLT SPACER
6	D3275-1	CROSS BOLT SPACER
2	D3286-1	DOUBLER
2	D3286-3	SPACER
1	D3289-041	FLOAT WEB
1	D3413-1	RING
1	D3415-041	NUT PLATE
1	D3535-15	WEARSHOE
1	D3535-21	WEARSHOE
1	D3535-35	WEARSHOE
1	D3535-41	WEARSHOE
1	D3536-15	GASKET
1	D3536-21	GASKET
1	D3536-35	GASKET
1	D3536-41	GASKET
7	D3537-1	WEARPAD
1	D3537-3	WEARPAD
12	D3683-1	INSERT
64	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
66	AN3C4A	BOLT
1	AN4C5A	BOLT
1	AN960C416	WASHER
78	AN960C10L	WASHER
2	CCR264SS3-3	RIVET
2	CR3212-4-03	RIVET
52	CR3212-4-04	RIVET
12	MS27039C1-05	SCREW (or AN3C3A BOLT)
2	NAS1515H3L	WASHER

#### GENERAL NOTES:

- MATERIAL: N/A
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: NONE
- WEIGHT: 20.8 LBS
- DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- BOND D3289-041 FLOAT WEB INTO D3288-1 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
- ALL HOLES DRILLED ON CENTERLINES EXCEPT WHERE SHOWN
- DRILL Ø0.297 HOLES FOR D3683-1 INSERTS BEFORE FINISH. INSTALL D3683-1 INSERTS AFTER FINISH
- DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3288-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX-241/-291
- WELDING: PER DART QSI 004
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

RELEASED  
C9/16/16 AM DU

G	REFORMAT DWG. RMV LPS-3 (ZN B6-3) RMV C'BORE & ADD SECTION K-K (ZN C2-4)	CP	09.06.17
F	SUBSTITUTE FLOAT BAG INSERT W/SPEC CTRL DWG WAS ALS7-1032-130; IS NOW D3683-1	DC	07.11.21
E	MID-FLOAT HOLES WERE MOVED 2.00" FWD AND ROTATED INBOARD AND OUTBOARD BY 17° INSERTS ARE NOW INSTALLED AT THESE LOCATIONS	MB	07.09.14
D	DIMENSIONS ADDED	DC	07.06.04
C	NEW INSERTS, SS WEARSHOES AND GASKETS	PH	06.12.19
B	CHANGE INSERTS	CP	05.03.18
A	NEW ISSUE	CP	04.05.17
REV.	DESCRIPTION	BY	DATE

DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3288	SHEET 1 OF 4
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DE APPR.		SKIDTUBE ASSEMBLY	NTS
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# 79329

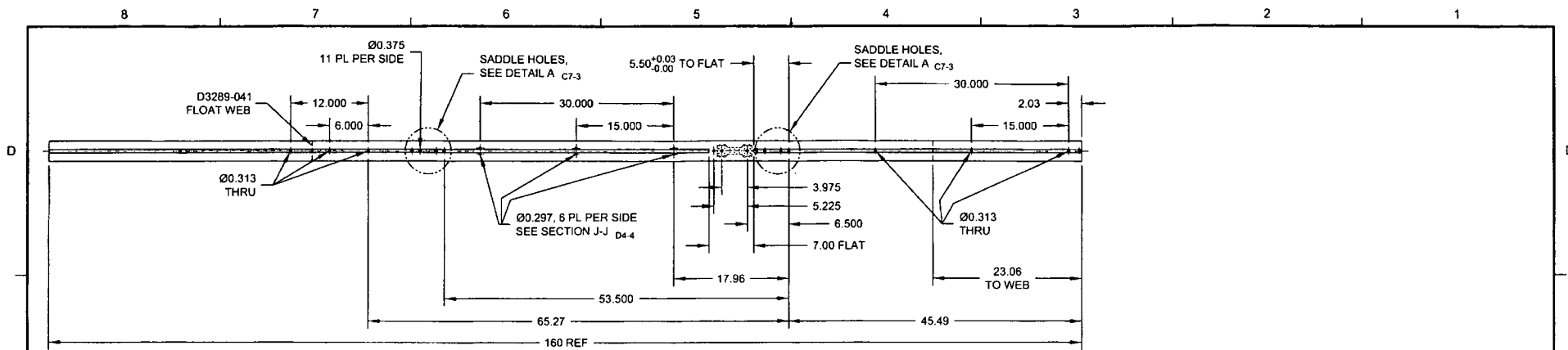
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

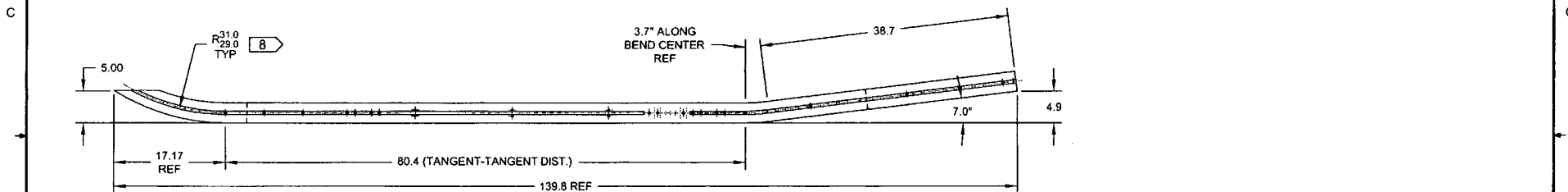
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

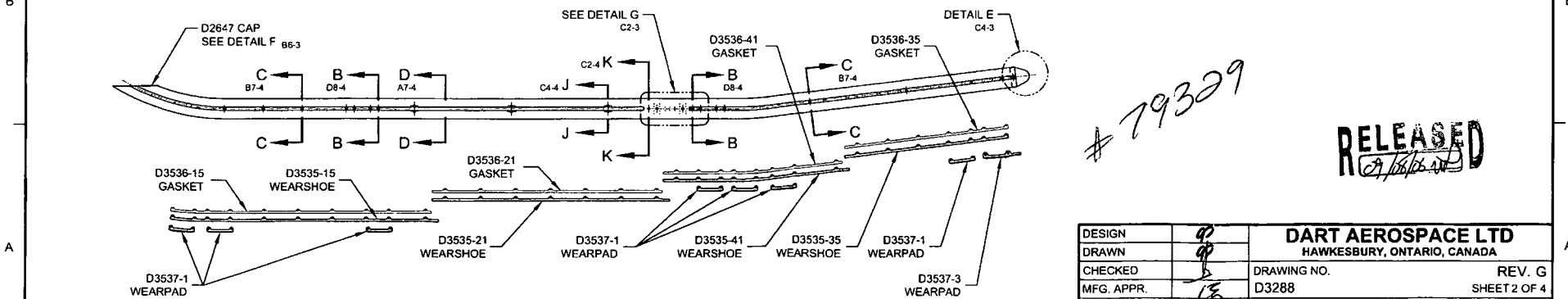
**NOTE:** Date & initial all entries



**D3288-041 DRILLING/WEB ASSEMBLY DETAIL**



**D3288-041 BENDING DETAIL**



**D3288-041 WELDING DETAIL/SKIDTUBE ASSEMBLY**

# 79329

**RELEASED**

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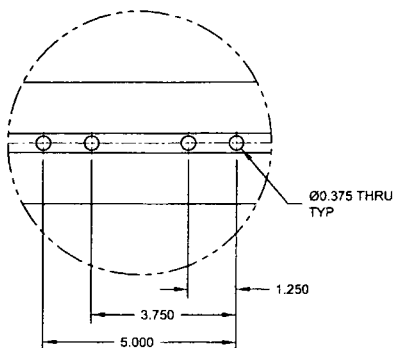
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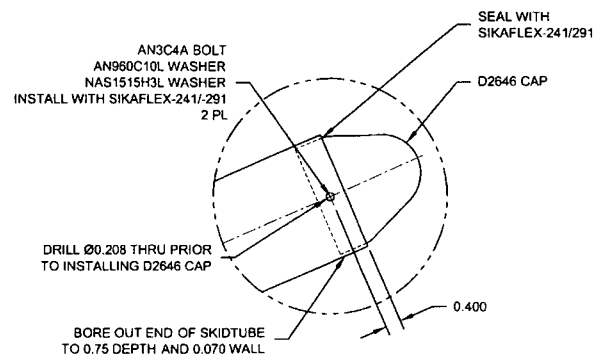
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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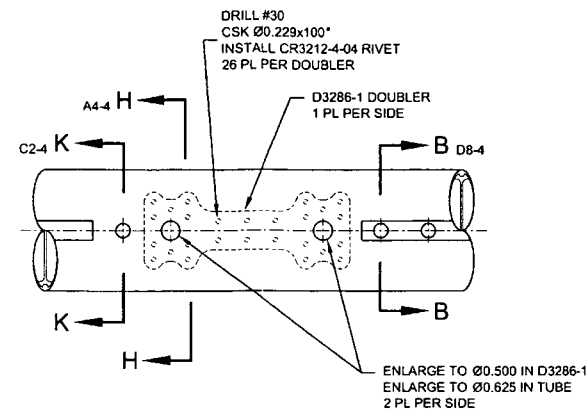




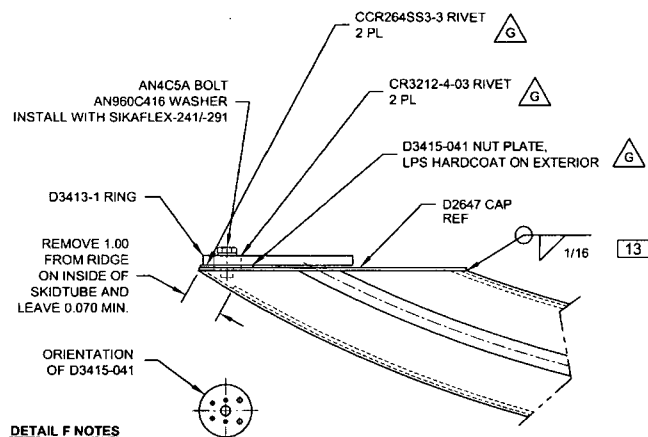
**DETAIL A: DRILL DETAIL** D6-2, D4-2  
SADDLE HOLES, SCALE 5X



**DETAIL E** B3-2  
SCALE 5X



**DETAIL G** B5-2  
SCALE 5X



**DETAIL F NOTES**

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE  
NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

**DETAIL F: END FINISHING DETAIL** B7-2  
SCALE 5X

# 79329

**RELEASED**  
9/16/16

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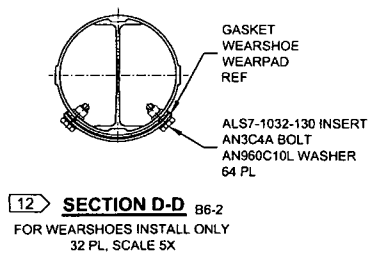
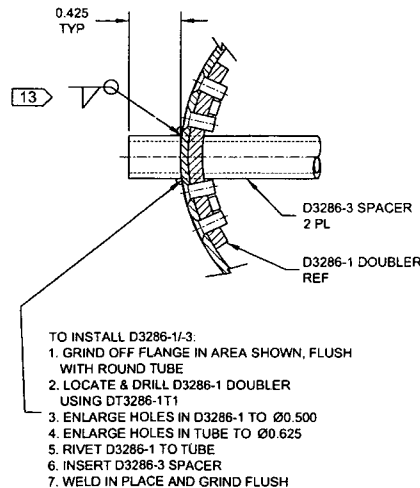
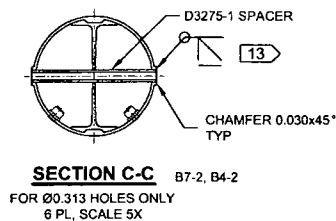
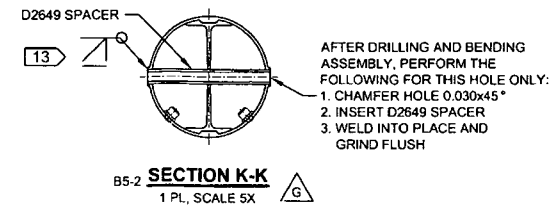
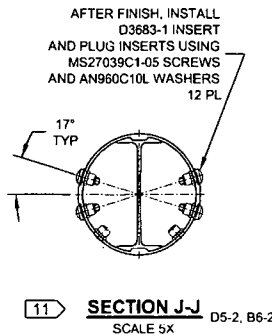
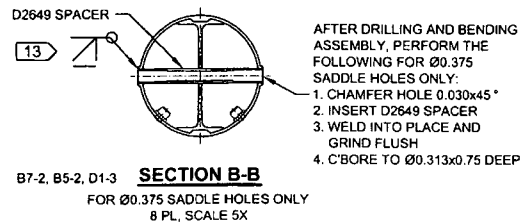
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



# 79329

RELEASED  
09/18/06

DESIGN	99	DART AEROSPACE LTD	
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**NOTE:** Date & initial all entries

4.9 206A/B HIGH GEAR FLOAT SKIDTUBES, TRI-BAG COMPATIBLE (D206-642)  
 32.19 206A/B HIGH GEAR FLOAT SKIDTUBES, TRI-BAG COMPATIBLE (ICA-D206-642)

ITEM	QTY -611	QTY -612	QTY -613	QTY -614	QTY -641	QTY -654	PART NUMBER	DESCRIPTION
	X						D206-642-611	SKIDTUBE INSTALLATION, LH
		X					D206-642-612	SKIDTUBE INSTALLATION, RH
			X				D206-642-613	SKIDTUBE INSTALLATION, LH, THRU BOLT
				X			D206-642-614	SKIDTUBE INSTALLATION, RH, THRU BOLT

IS:

12B	16	16	16	16			D3672-7	WASHER
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WAS:

12B	16	16	16	16			D3672-5	WASHER
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6866

DESIGN	CP	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
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MFG. APPR.	N/A	DSI 9467	SHEET 2 OF 2
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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